

Date: Thursday, 18/06/2009 7:23:15 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB/ GUSSET ASSY
Job Number : 48644	
Estimate Number : 13651	
P.O. Number :	Part Number : D3826041
This Issue : 18/06/2009 S.O. No. :	Drawing Number : D3826 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing/Revision : B
Previous Run : 48431	Material :
Written By : _____	Due Date : 25/06/2009 Qty: 6 Um: Each
Checked & Approved By : _____	
Comment : Est Rev.A 08.12.01 new issue DD verified by:EC Est Rev.B 09.04.27 rev B dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22351	Basket Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Basket Rib

batch: B48451 → 3 B48665 → 3

PD 08.06.22

2.0	D3929041	Gusset Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Support Gusset (350 Basket)

batch: B47958 → 2 B48663 → 4

PD 08.06.22

3.0	D3929042	Gusset Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Gusset Assembly

B47959 → 2 B48662 → 4

PD 09.06.22

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D3929 support gusset together

2- locate D3929 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M108160

PD 09.06.22 (6)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 09.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/06/2009 7:23:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB/ GUSSET ASSY

Job Number: 48644

Part Number: D3826041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

507/06/23

(K6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

10 09-06-23

(G)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



mf
09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

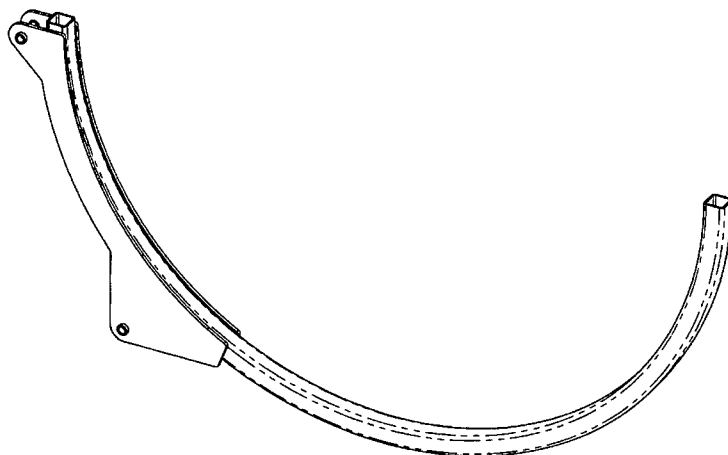
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△/B



D3826-041 RIB/GUSSET ASSY

W/O 48644

RELEASED
8/10/12

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 3.32 lbs

△/B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN				
CHECKED				
MFG. APPR.	DRAWING NO. D3826		REV. B	
APPROVED	TITLE RIB/GUSSET ASSY		SHEET 1 OF 2	
DE APPR.	SCALE		NTS	
DATE	09.04.16		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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△ B D3929-042
GUSSET ASSEMBLY

△ B D3929-041
GUSSET ASSEMBLY

TYP

0.250

℄

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

Mo 48644

RELEASED
9/04/16

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3826	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB/GUSSET ASSY	NTS
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8 7 6 5 4 3 2 1